

4

Date: Wednesday, 4/4/2007 8:57:06 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LEFT ARM WELDMENT
Job Number : 31586	
Estimate Number : 12080	
P.O. Number : <u>N/A</u>	Part Number : D33543
This Issue : 4/4/2007	Drawing Number : D3354 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u>	Drawing Revision : B
Previous Run : 30399	Material : <u>N/A</u>
	Due Date : 4/11/2007
Written By : _____	Qty: 4 Um: Each
Checked & Approved By : <u>07.04.04</u>	
Comment : est rev A 06.01.23 new issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NR1250	4130N ROUND BAR
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Comment: Qty.: 0.6300 f(s)/Unit Total : 2.5200 f(s)  
AISI 4130 ROUND BAR 1.250" dia. batch: M104182

DSP 07/07/27

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: 1-TURN AS PER FOLIO FA623 & DWG D3354  
FOLIO REV: AA  
DWG REV: 3

2-DEBURR AS REQUIRED

DSP 07/07/27

4

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DSP 07/07/27

4

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE  
1-Drill cotter pin hole as per dwg D3354

2-Debur

070802

4

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07/08/03

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 9/08/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 8:57:06 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEFT ARM WELDMENT

Job Number: 31586

Part Number: D33543

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*E/S 07/08/03 (4)*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

*07/08/03*

Job Completion



*07-08-03*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 31586
<b>Description:</b> Wheel Shaft		<b>Part Number:</b> D3354-3
<b>Inspection Dwg:</b> D3354	<b>Rev:</b> A B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.04	+/-0.030	7.0435	✓			
4.020	+0.010/-0.000	4.020	✓			
0.85	+/-0.030	0.845	✓			
0.06	+/-0.030	0.06	✓			
0.13	+/-0.030	0.13	✓			
Ø1.250	+0.001/-0.004	1.248	✓			
Ø1.103	+0.001/-0.002	1.103	✓			
<del>0.750 Thread</del>	<del>+/-0.010</del>					
0.03 x 45°	+/-0.030 x 0.5°	.03 x 45°	✓			
Ø0.152	+0.005/-0.001	.152	—			
R0.02	+/-0.030	R.015	✓			
R0.050	+/-0.010	0.05	✓			
0.660	+/-0.010	.660	—			
<del>Ø0.152</del>	<del>+0.005/-0.001</del>					
Thread 0.7438	+0.0047	0.7445	✓			

For 07/07/27

<b>Measured by:</b> DAP / AS	<b>Audited by:</b> S.F.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/07/27/070802	<b>Date:</b> 07/08/03	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	

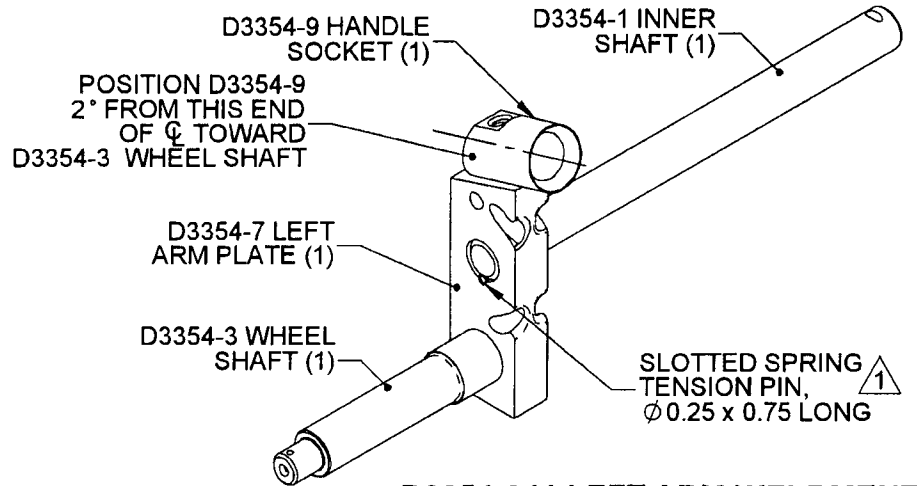
AS



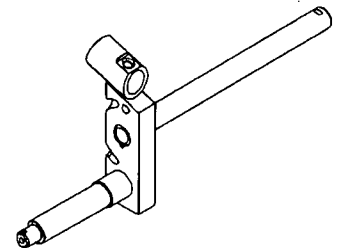


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CHECKED <i>h</i>	APPROVED <i>h</i>	DRAWING NO. <b>LEFT ARM WELDMENT</b>	REV. B SHEET 1 OF 7
DATE <b>07.02.02</b>	TITLE <b>D3354</b>	SCALE 1:4	
REV	DATE	DESCRIPTION	
A	04.12.13	NEW ISSUE	
B	07.02.02	REVISED DIMENSIONS	

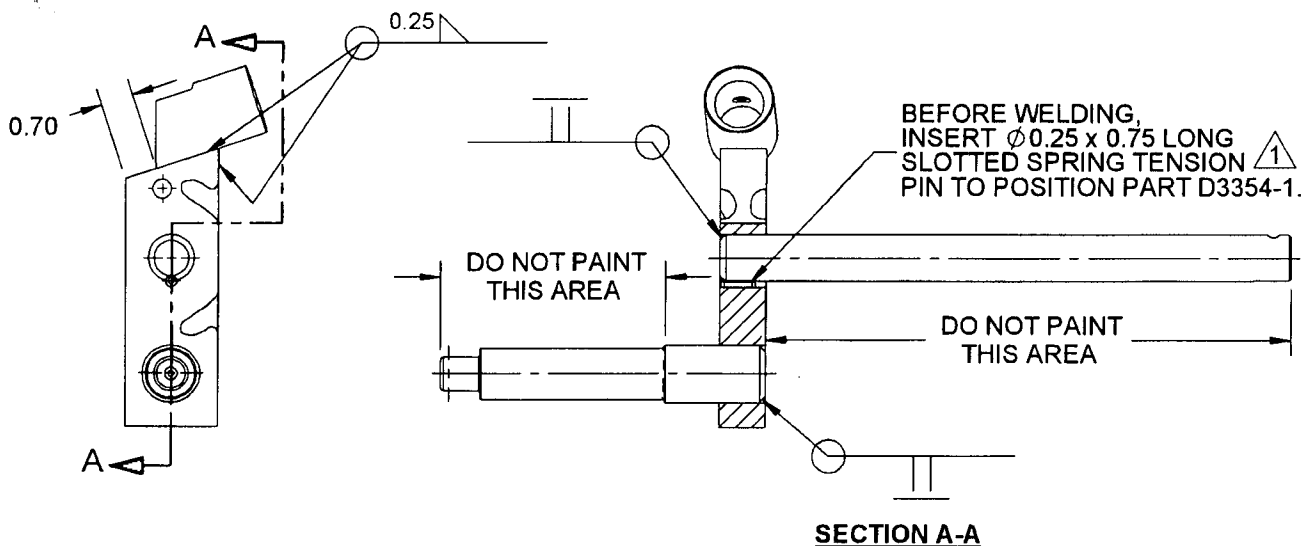
**RELEASED**  
07.02.02



**D3354-041 LEFT ARM WELDMENT**



**D3354-042 MIRROR ARM WELDMENT**



**NOTES:**

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

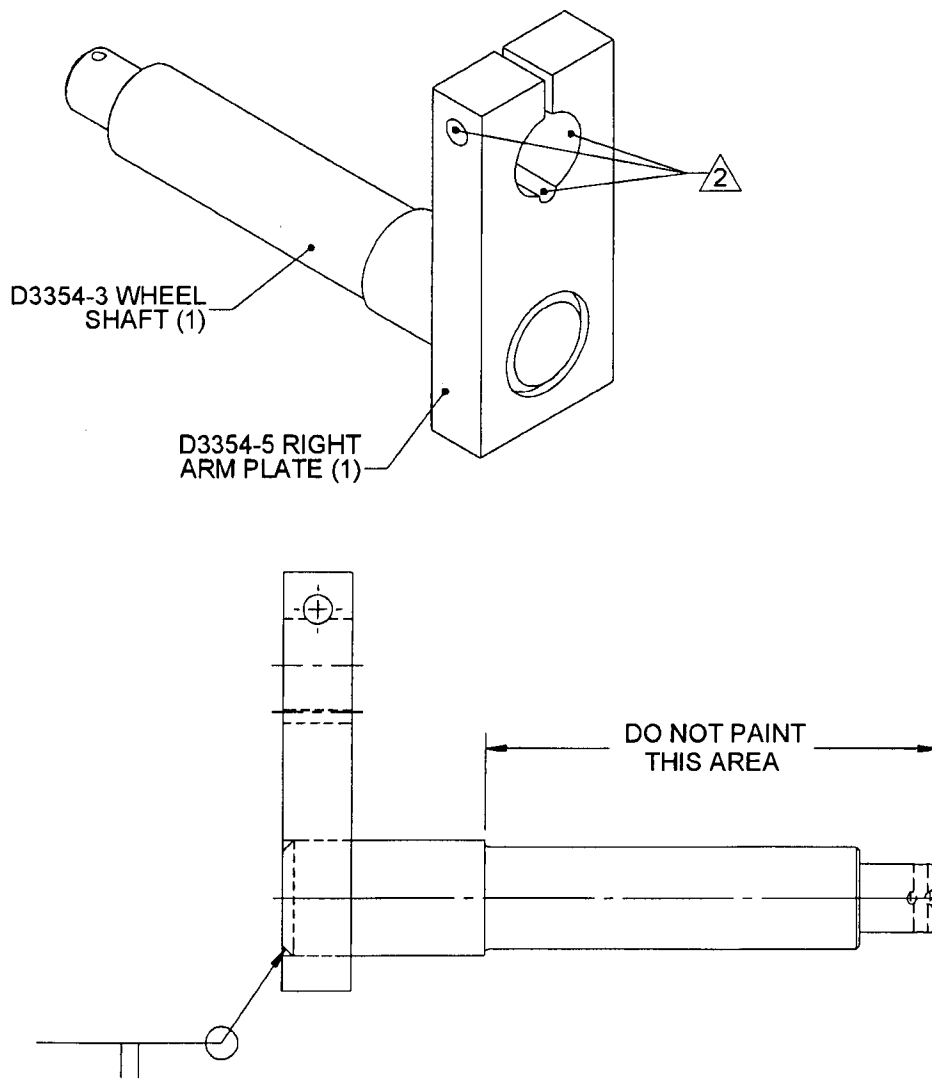
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DATE <b>07.02.02</b>		TITLE <b>LEFT ARM WELDMENT</b>	SCALE 1:2

**RELEASED**  
*[Stamp]* 07.02.02**D3354-043 RIGHT ARM WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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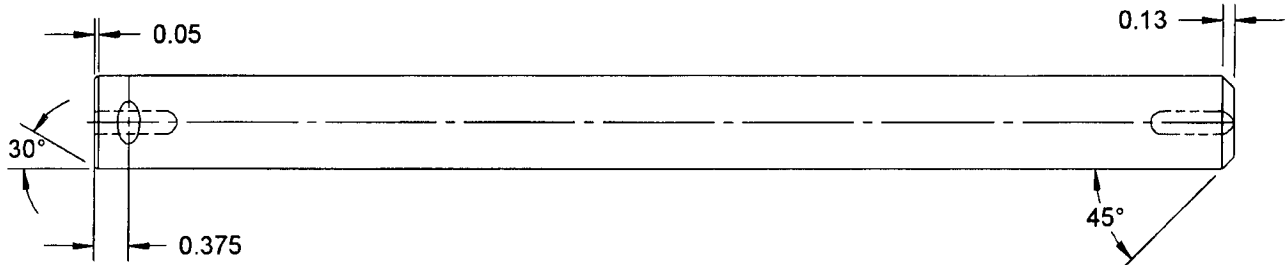
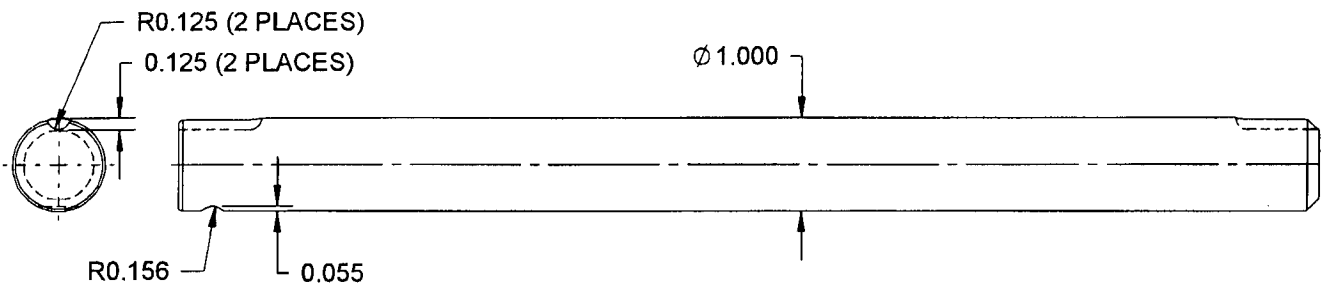
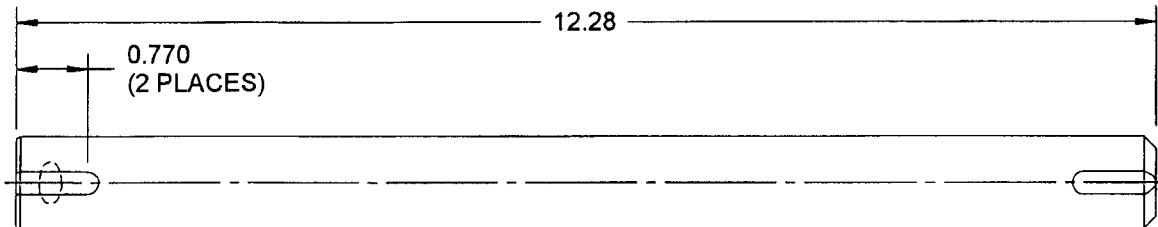






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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:2

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### D3354-1 INNER SHAFT

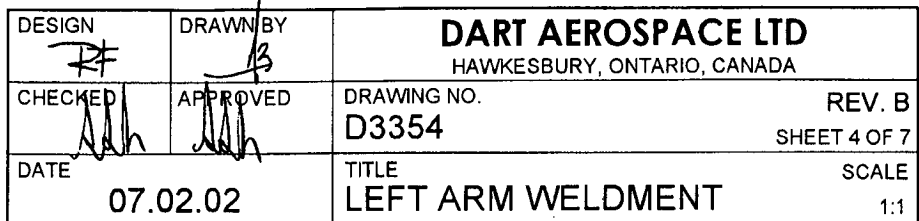
#### NOTES:

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91  
OR UNS# G41400 ROUND BAR,  $\phi 1.250$  (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

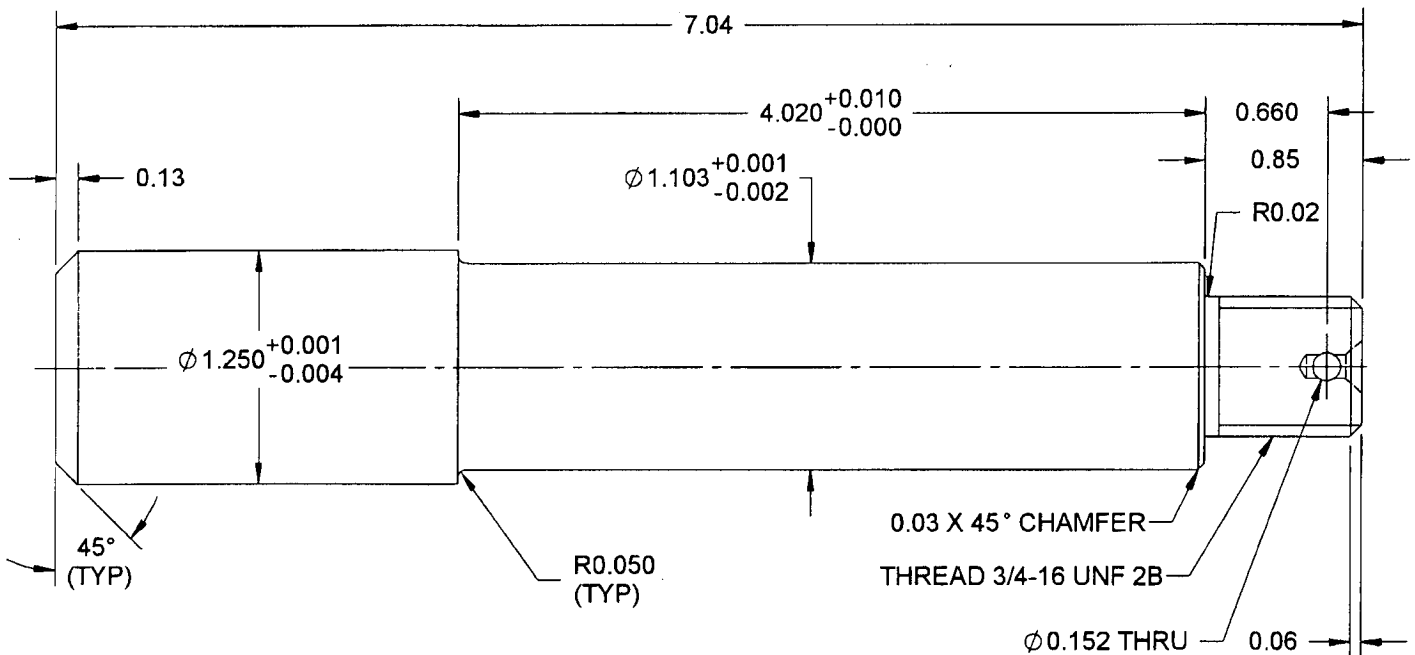
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**NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91  
OR UNS# G41400 ROUND BAR, Ø1.250 (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
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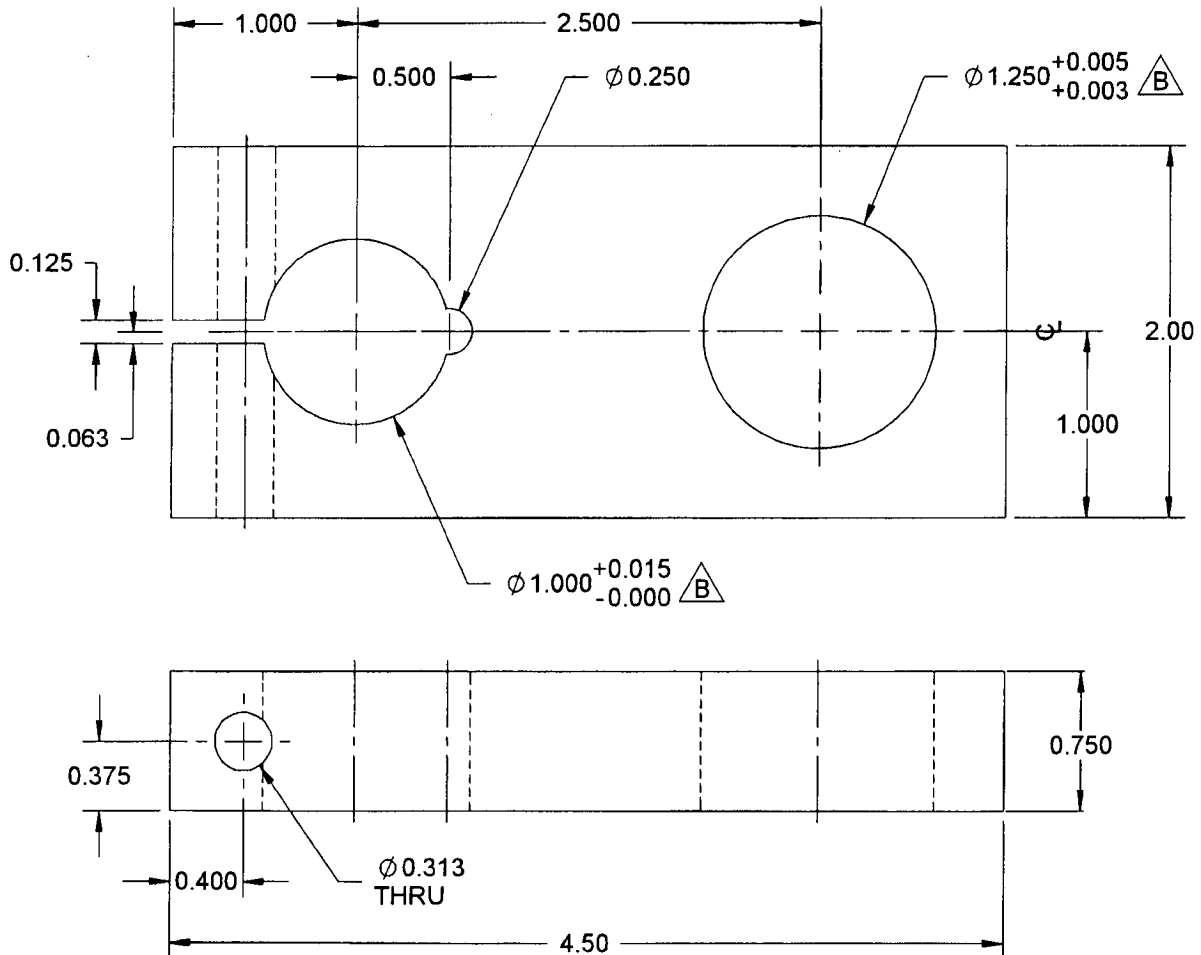
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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:1

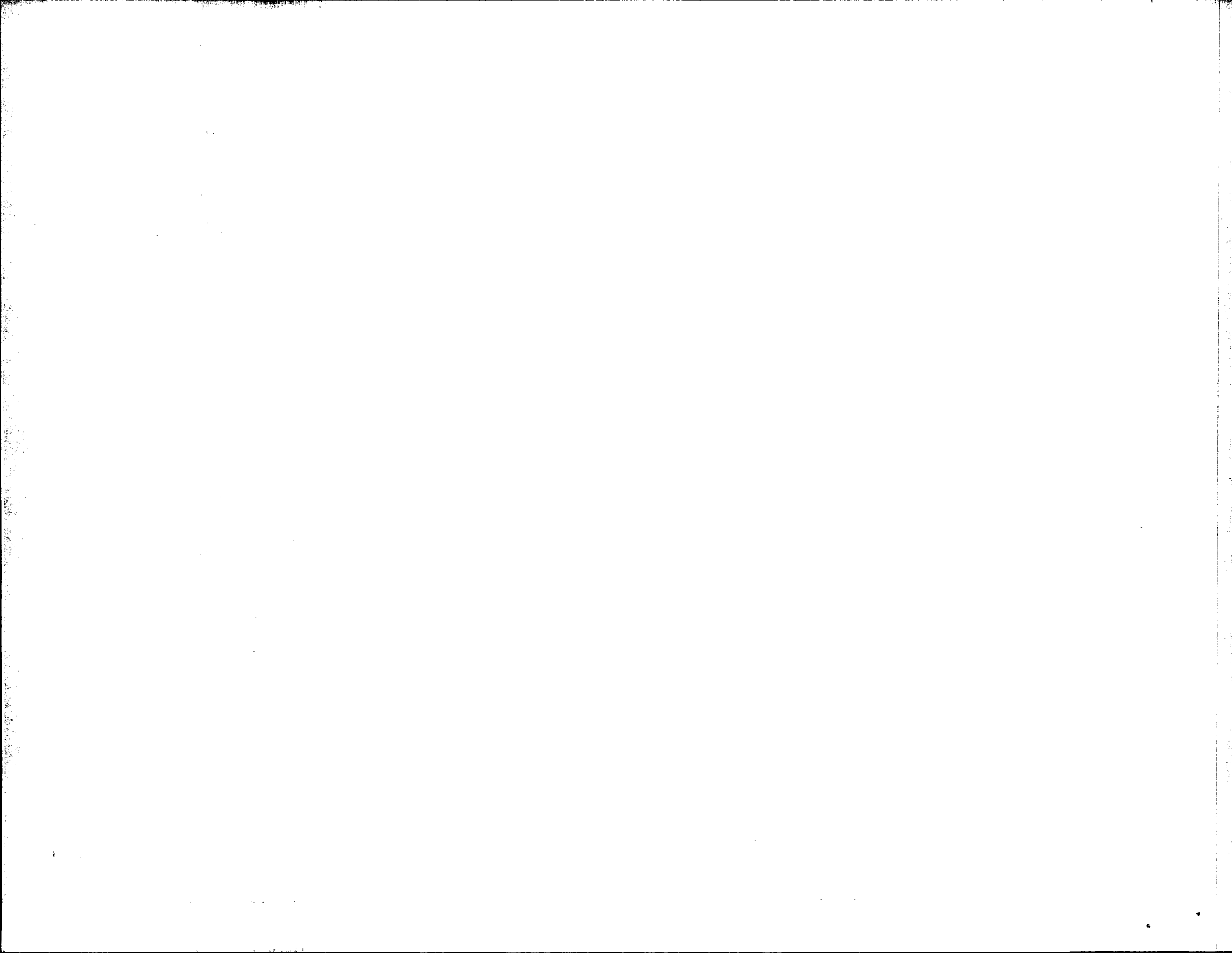
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*h* 07.02.02**D3354-5 RIGHT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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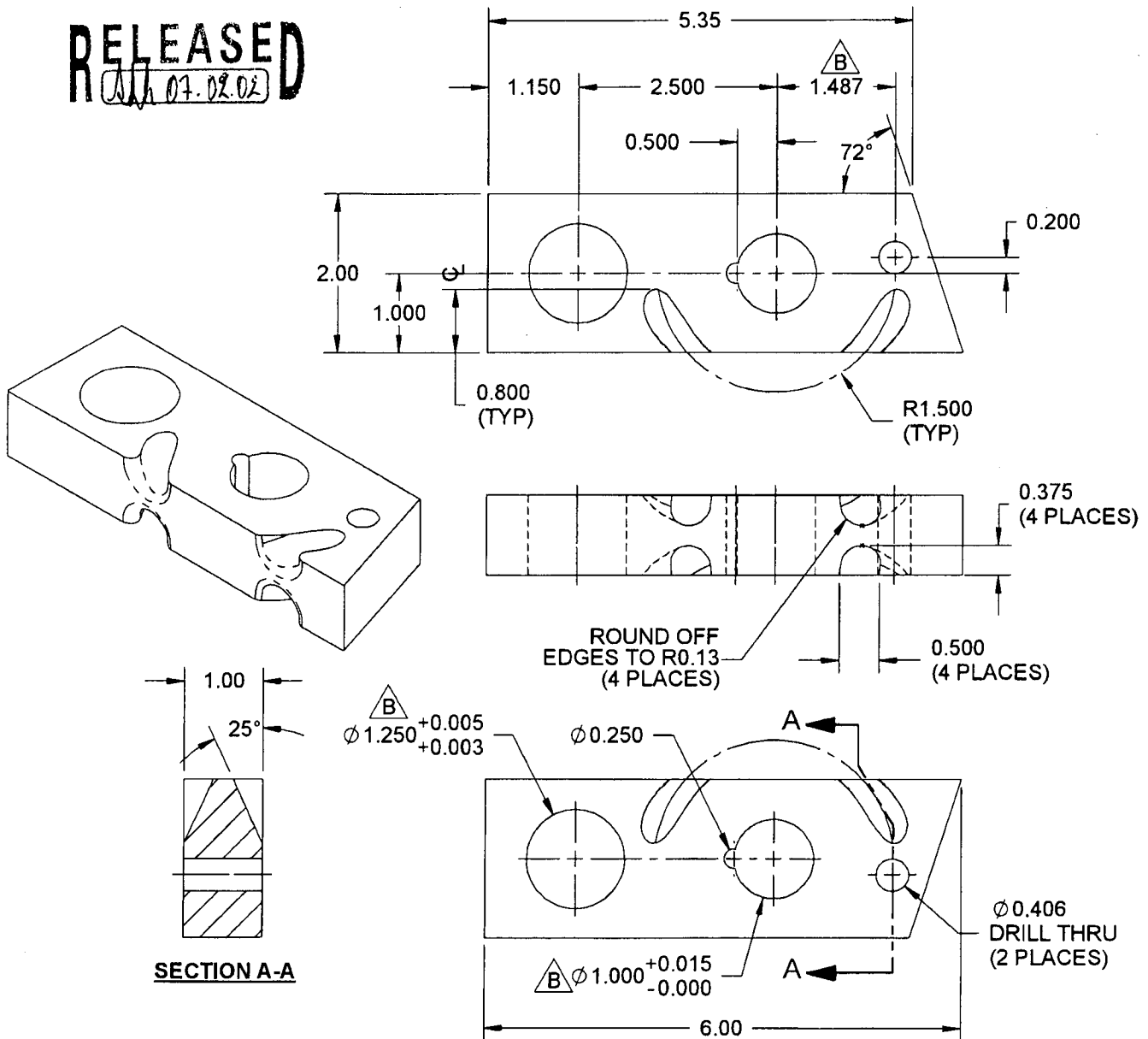
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DATE <b>07.02.02</b>	TITLE <b>LEFT ARM WELDMENT</b>		SCALE 1:2

**RELEASED**  
*07.02.02***D3354-7 LEFT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

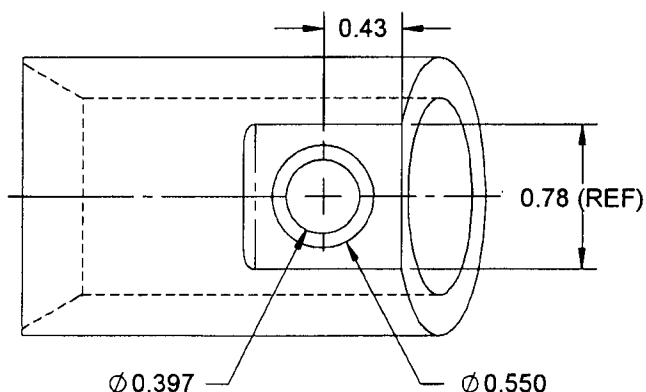
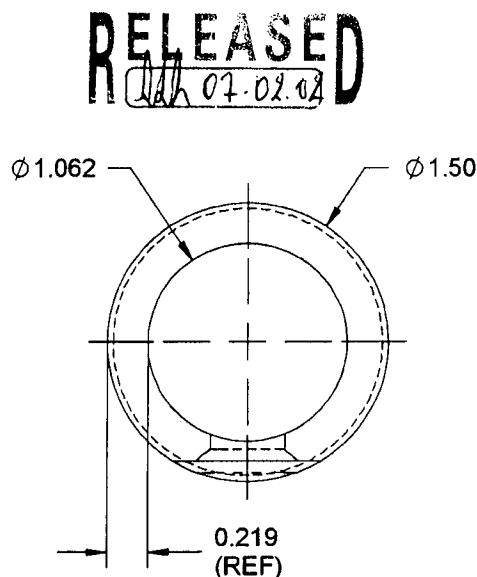
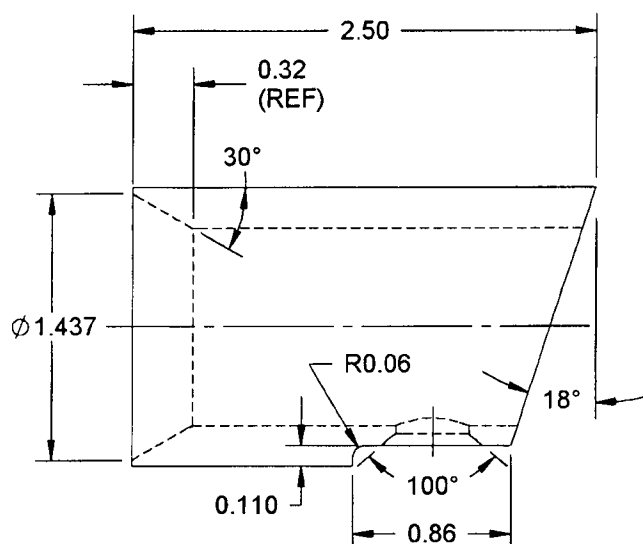
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DATE 07.02.02	TITLE LEFT ARM WELDMENT		SCALE 1:1



### D3354-9 HANDLE SOCKET

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 SEAMLESS ROUND TUBING PER MIL-T-5066 OR  
ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077,  
(REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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